



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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D5489-047
Job Sheet 193270



Part No: D5489-047

Job Qty: 12 pcs

Part Name: Wearplate Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/10/19

Job Tracking No:

Due Date: 5/16/19

Created By: Shannon Hadley

Type: SOLD

Description:

Note: DWG D5489 REV.B IPP REV:A 17.11.03 AS PER DWG REV.A DD VERF:JFS IPP REV:B 18.08.15 AS PER
DWG REV.B DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs		5/16/19	0.00	1.20	Waterjet - Flow	8/6/19	JRB
110	QC 2	12 pcs		5/16/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		JRB 8/6/19
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

120 QC 8	12 pcs	5/16/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
130 Small Fab - Brake NC - B4B	12 pcs	5/16/19	0.00 0.60	Small Fab - Brake - 1 - B4B	DAS 30 9-89 AUG 1 5 2019
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
140 QC 5	12 pcs	5/16/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	Q
				QC 5 - 30	
				QC 5 - 40	
150 Automated Welding - B4B	12 pcs	5/16/19	0.00 1.50	Automated Welding - 1 - B4B	MV MR
160 QC 10	12 pcs	5/16/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	Q
				QC 10 - 58	
170 QC 5	12	5/16/19	0.00 0.00	QC 10 - 9	
				QC 5 - 10	

pcs				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	52
				QC 5 - 30	
				QC 5 - 40	
180 Handfinish - 4-1-Assembly-B4B	12 pcs	5/16/19	0.00 2.40	Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	19-8-15
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
190 QC 3	12 pcs	5/16/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
200 Packaging 3-1 - Stock - B4B	12 pcs	5/16/19	0.00 0.00	QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	

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AUG 16 2019 40
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				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - SA	12 pcs	5/16/19	0.00 0.00	QC 21 - SA - 21	DAS 21
				QC 21 - SA - 70	9-AUG 16 2019
				QC 21 - SA - 53	

Part Op **100** - 1-Cut as per Dwg (D5489-7) Dwg Rev: B Prog Rev: B 2-Deburr if necessary

Descriptions: **110** - (QC2- Inspect parts off machine FAI/FAIB)

120 - (QC8- Inspect parts - second check)

130 - (Form as per dwg)

140 - (QC5- Inspect part completeness to step on W/O)

150 - ***SEE NOTE 9 FOR SURFACE BUILDUP*** 1- WELD AS PER DWG AND QSI004 4.5 FOR AUTOMATED WELDING USE 8259 HARDCOAT BATCH: _____

160 - (QC10- Inspect visual per QSI004- ground welds)

170 - (QC5- Inspect part completeness to step on W/O)

180 - (Assemble as per dwg) COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER DWG AND PER QSI005 A/R ROCKGUARD BATCH: 5200412

190 - (QC3- Inspect Part Finish)

200 - (Identify as per dwg & Stock Location: _____) LOCATION : FP002

210 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	1.9200 sf (.16 ea)	100-Waterjet - Flow - 1	5179460

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	2	270	0

Part Specifications
Specifications could not be found.



Dart Aerospace Ltd.
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D5489-047 Job Sheet 193222



Part No: D5489-047

Job Qty: 12 ea

Part Name: Wearplate Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/9/19

Job Tracking No: 13643

Due Date: 5/16/19

Created By: Dara Macdonald

Type: SOLD

Description:

Note: DWG D5489 REV.B IPP REV:A 17.11.03 AS PER DWG REV.A DD VERF:JFS IPP REV:B 18.08.15 AS PER DWG REV.B DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs		5/16/19	0.00	1.20	Waterjet - Flow		
110	QC	12 pcs		5/16/19	0.00	0.00	QC2 Waterjet-4		
120	QC	12 pcs		5/16/19	0.00	0.00	QC8-6		
130	Brake NC	12 pcs		5/16/19	0.00	0.60	Brake NC 1		
140	QC	12 pcs		5/16/19	0.00	0.00	QC5		
150	Automated Welding - B4B	12 pcs		5/16/19	0.00	1.50	Automated Welding - 1 - B4B		
160	QC	12 pcs		5/16/19	0.00	0.00	QC10		
170	QC	12 pcs		5/16/19	0.00	0.00	QC5		
180	HandFinish	12 pcs		5/16/19	0.00	2.40	HandFinish4		
190	QC	12 pcs		5/16/19	0.00	0.00	QC3		
200	Packaging	12 pcs		5/16/19	0.00	0.00	Packaging3-2		
210	QC21-SA	12 Ea		5/16/19	0.00	0.00	QC21		

Part Op 100 - 1-Cut as per Dwg (D5489-7) Dwg Rev: _____ Prog Rev: _____ 2-Deburr if necessary
Descriptions: 150 - ***SEE NOTE 9 FOR SURFACE BUILDUP*** 1- WELD AS PER DWG AND QSI004 4.5 FOR AUTOMATED WELDING USE 8259 HARDCOAT BATCH: _____
180 - COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER DWG AND PER QSI005 A/R ROCKGUARD BATCH: _____
200 - LOCATION : FP002

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	1.9200 sf (.16 ea)	100-Waterjet - Flow - 1	
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	2	270	0
Part Specifications				
Specifications could not be found.				

Plex 4/9/19 1:51 PM Dart.Macdonald.Dara

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Container No: S203056



Part: D5489-047

Job No: 193270

Serial No/Batch: S203056

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/06/19